

Work Order ID 75463

75463

Page 1

October 24, 2011 9:45:39 AM

Item ID: D3186-2M Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: SPACEPOD DOOR RH
 Start Date: 10/24/11 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 11/09/11 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: CD Date: 11/10/24 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3186	Rev E								

100 PURCHASING 0.00

100

Purchasing

Purchasing

Memo

Issue P/O:

15233

Description: D3186-2MDoor

Supplier: Delastek

Conformity Certificate and Process sheet required

Ship 3 Items from Previous steps

CD 11/10/24 ①

110 Receive & Inspect for Damage & Mat'l Certs 0.00

110

Packaging

Packaging

Memo

Ensure a copy of certification of conformity and process sheet from Delastek is attached.

11/24/11 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

- Work Order ID 75463

75463

Page 2

October 24, 2011 9:45:39 AM

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- Inspect dimensions to drawing	0.00							
120									
QC	Memo	0.00							
Quality Control	Check for void spot and pins.								
130	Identify as per dwg & Stock Location: <u>Composites</u>	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

12/4/11
MF
12-04-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

October 24, 2011 9:45:38 AM

Page 1

Work Order ID: 75463

Parent Item: D3186-2M

Start Date: 10/24/11

Required Date: 11/09/11

Parent Item Name: SPACEPOD DOOR RH

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 06-12-04 ec
IPP rev D rv D dwg 07.03.07 ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3186-2P Spacepod Door		Purchased	No			110	Each	0.0000	1	1		12-03-29	

B75463

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

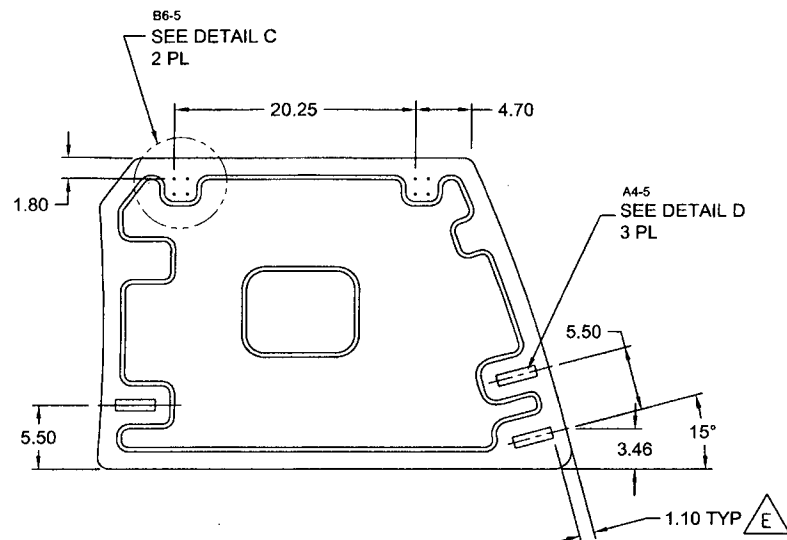
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

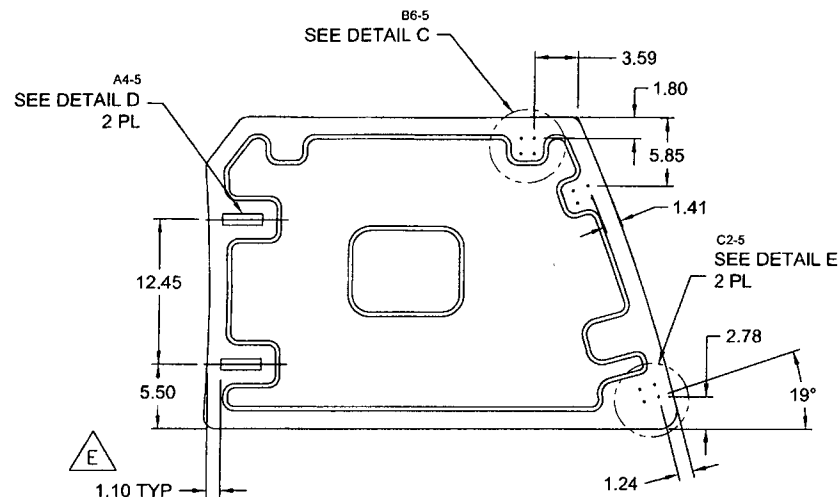
8 7 6 5 4 3 2 1



D3186-1 SPACEPOD DOOR, LH
MAKE FROM D3186-1M





NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A



D3186-3 SPACEPOD DOOR, LH
MAKE FROM D3186-1M

RELEASED
2009-09-09

E	DRAWING UPDATED TO CURRENT STANDARDS. 1.10 WAS 0.98 (ZN B5-1, B4-1, B7-2, B1-2); R0.12 WAS 0.125 (ZN B5-5); REF PAR 09-026		RF	09.07.08
D	UPDATE DIMENSIONS		LE	07.02.22
C	REMOVED D0600-XXX LABELS		LE	06.12.13
B	DIMS UPDATED TO MATCH PRODUCT FOAM PATTERN UPDATED D3186-1M/-2M/-3/-4 ADDED		LE	06.09.25
A	NEW ISSUE		CP	03.03.27
REV.	DESCRIPTION		BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	RF			
CHECKED		DRAWING NO.	REV. E	
MFG. APPR.		D3186	SHEET 1 OF 5	
APPROVED		TITLE	SCALE	
DE APPR.		SPACEPOD DOOR	NTS	
DATE	09.07.08	COPYRIGHT © 2003 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>		

8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

C

B

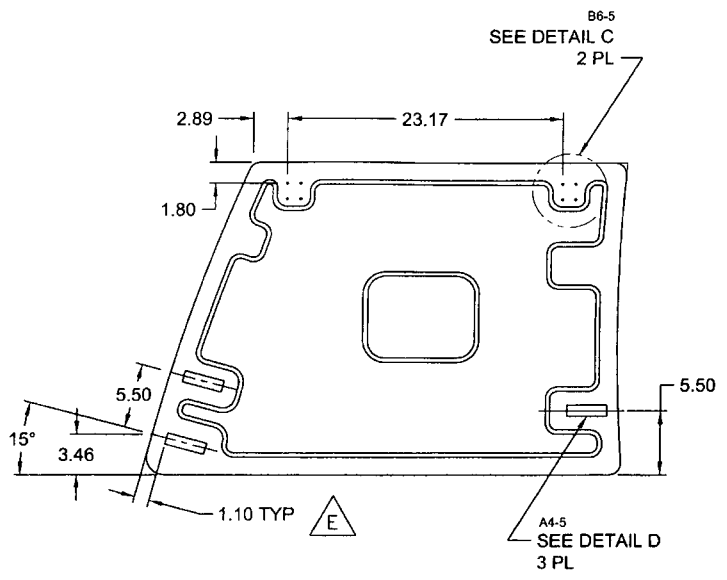
A

D

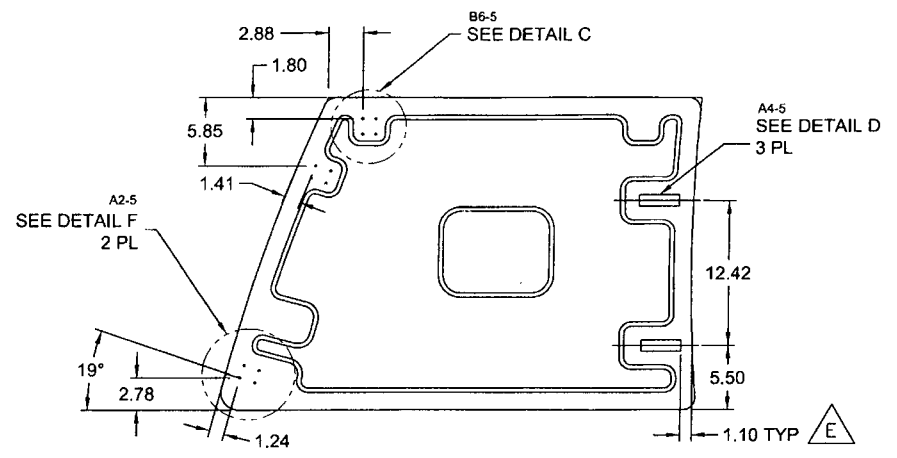
C

B

A



D3186-2 SPACEPOD DOOR, RH
MAKE FROM D3186-2M



D3186-4 SPACEPOD DOOR, RH
MAKE FROM D3186-2M

RELEASED
2009-09-09

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: N/A

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3186	SHEET 2 OF 5
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8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

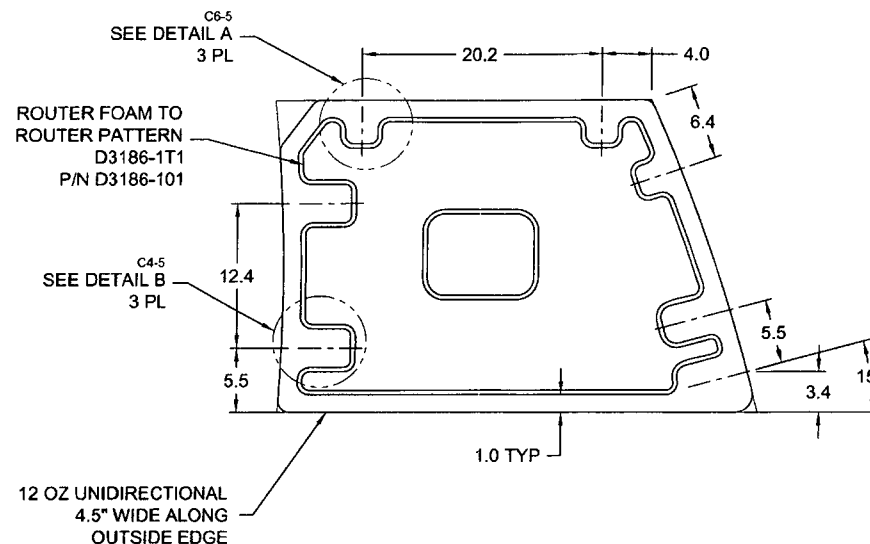
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

MAIN LAYUP
 9 OZ SATIN (9 SQ FEET)
 9 OZ SATIN (9 SQ FEET)
 FOAM
 9 OZ SATIN (9 SQ FEET)
 12 OZ UNIDIRECTIONAL
 9 OZ SATIN (9 SQ FEET)
 RESIN (35-45% BY WEIGHT)
 PEEL PLY



D3186-1M SPACEPOD DOOR AS MOLDED

NOTES:

1) MATERIAL:

RESIN = EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
 FOAM = 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
 FIBRE = 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
 12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
 LAMINATE PER DART QSI 006 4.0
 LAMINATION SCHEDULE PER THIS DRAWING

2) FINISH: FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: 7.0 lbs

8) USE MOLD DT8005 FOR DOOR LAYUP

RELEASED
 2008-08-08

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. E
MFG. APPR.		D3186	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SPACEPOD DOOR	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

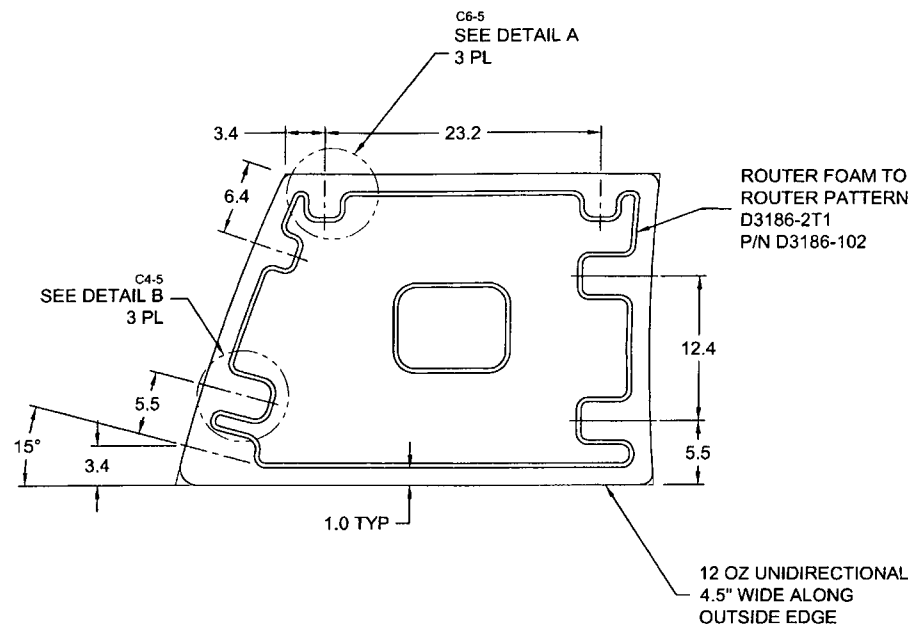
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NOTE: Date & initial all entries

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 9 OZ SATIN (9 SQ FEET)
 FOAM
 9 OZ SATIN (9 SQ FEET)
 12 OZ UNIDIRECTIONAL
 9 OZ SATIN (9 SQ FEET)
 RESIN (35-45% BY WEIGHT)
 PEEL PLY



NOTES:

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 RESIN = EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
 FOAM = 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
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- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 7.0 lbs
- 8) USE MOLD DT8006 FOR DOOR LAYUP

D3186-2M SPACEPOD DOOR AS MOLDED

RELEASED
 2008-08-09

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. E
MFG. APPR.	RF	D3186	SHEET 4 OF 5
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	SPACEPOD DOOR	NTS
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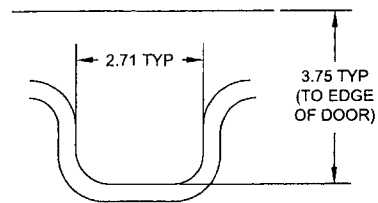
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

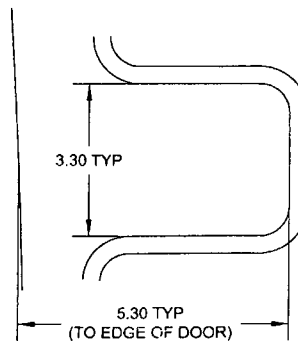
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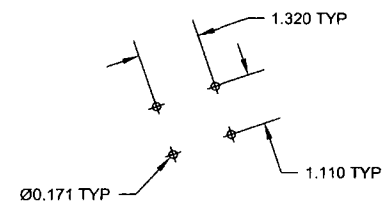
NOTE: Date & initial all entries



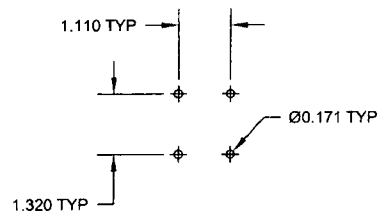
DETAIL A D6-3
SCALE 4X D4-4



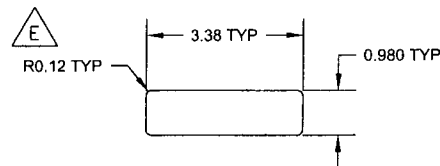
DETAIL B C6-3
SCALE 4X C6-4



DETAIL E C1-1
SCALE 4X

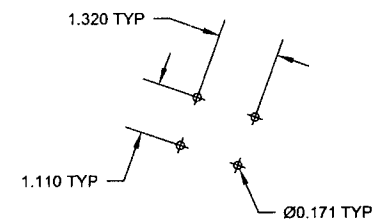


DETAIL C D7-1
SCALE 4X D3-1
D6-2
D3-2



NOTE: ENSURE THAT CUTOUT IS PERPENDICULAR TO EDGE OF DOOR

DETAIL D C5-1
SCALE 4X D4-1
B6-2
C2-2



DETAIL F C4-2
SCALE 4X

RELEASED
2009-09-09

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3186	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SPACEPOD DOOR	NTS
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Mardi, 2011-10-25 18:32:50
 Utilis : Pascal Carignan

Feuille de Procédé

Client : DART US DART AEROSPACE LTD	Nom Dessin : SPACEPOD DOOR RH
Numéro Job : 36774	Numéro Article : DKC134-0060
Numéro Soumission : 3769	Numéro Dessin : D3186
Numéro B.A. :	Projet Numéro : DK-362
Cette fois : 2011-10-25 No. B.V. :	Révision dessin : E
Prsht Rev. : NC	Matériel : 7781 & 411-350
Prem. fois : - - Type :	Date Dûe : 2011-11-01 Qté: 1 Udm: UNITE
Job précédente : 34979	
Écrit par : _____	
Vérifié & Approuvé par : _____	
Commentaires : N° de pièce Client: D3186-2M	

B 75463

 Process Sheet Rév.: 02 Modifier le N° de projet DK-359 pour
 DK-362, AAC1885 était AC0883, AAC1887 était AC0884.

Produit additionnel

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
1.0	AAC1616	N° 83634, Frekote Loctite Wolo

 Commentair Qty.: 0.050 UNITE(s)/Unit Total : 0.050 UNITE(s)
 N° 83634, Frekote Loctite Wolo N° de Lot: _____

2.0	PRÉPARATION	Préparation du moule
-----	-------------	----------------------



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Faire la préparation du moule N° DT 8006 selon IG 0009.

Date: _____ Sceau: _____

3.0	AAC1885	Tissu à délaminer Release ply B
-----	---------	---------------------------------

 Commentair Qty.: 3.28 VERGE(s)/Unit Total : 3.28 VERGE(s)
 Tissu à délaminer Release ply B # de Lot: N/A


4.0	AAC1887	Wrightlon 5200 Bleu P3
-----	---------	------------------------

 Commentair Qty.: 3.59 VERGE(s)/Unit Total : 3.59 VERGE(s)
 Wrightlon 5200 Bleu P3 # de Lot: N/A


5.0	AC0885	Feutre de drainage N° Airweave N 10
-----	--------	-------------------------------------

Commentair Qty.: 3.00 VERGE(s)/Unit Total : 3.00 VERGE(s)

6.0	AC0943	Stretchlon 200 poche à vide Vert
-----	--------	----------------------------------

Commentair Qty.: 3.00 VERGE(s)/Unit Total : 3.00 VERGE(s)

7.0	AMB0214	9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish
-----	---------	---

 Commentair Qty.: 4.5 VERGE(s)/Unit Total : 4.5 VERGE(s)
 9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

N° de Lot: 1-31000-2

Date: Mardi, 2011-10-25 18:32:50
Utilisateur: Pascal Carignan

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 36774

Nom Dessin: SPACEPOD DOOR RH
Numéro Article: DKC134-0060

Numéro Job:



Séq.:

Machine ou Opération:

Description :

8.0 AC0886

Ruban à gommer jaune #: T/AT-200Y

Commentair Qty.: 2.2500 ROULEAU(s)/Unit Total : 2.2500 ROULEAU(s)

9.0 AMB0349

Fiberglass 12 oz Unidirectional

Commentair Qty.: 1.00 VERGE(s)/Unit Total : 1.00 VERGE(s)

Fiberglass 12 oz Unidirectional

N° de Lot: 1-22549-1

10.0 PREP-GENERAL

Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Tailler le matériel selon les différents patrons de découpe.

Appliquer le ruban jaune tout le tour du stretchlon 200 en laissant le papier sur le coté non en contact avec le sac à vide.

Afin d'accélérer le processus de taillage, tailler les plis de 9.7 oz. tous en même temps en les superposants les uns sur les autres.

Date: 09-11-11 Sceau:



11.0 AMB0286

Catalyst N° DDM-9

Commentair Qty.: 0.0080 GALLON(s)/Unit Total : 0.0080 GALLON(s)

Catalyst N° DDM-9

N° de Lot: 1-27829-1

12.0 AMB0212

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.500 LITRE(s)/Unit Total : 0.500 LITRE(s)

Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-32912-1

13.0 PREP-GENERAL

Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Faire la préparation de la résine selon les quantités requises, mix ratio 1.5% catalyst par quantité de résine.

Date: 9-11-11 Sceau:



14.0

LAMINAGE

Faire le laminage



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

À l'aide d'un rouleau de 2" dia. appliquer une couche de résine sur le moule et ensuite imbiber un pli de tissu 9.7 oz.

Date: 9-11-11 Sceau:



Date: Mardi, 2011-10-25 18:32:50
Utilisateur: Pascal Carignan

Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Numéro Job: 36774

Nom Dessin: SPACEPOD DOOR RH

Numéro Article: DKC134-0060

Numéro Job:



Séq.:

Machine ou Opération:

Description :

15.0

BAGGING

Faire le bagging sur la pièce



Commentaire Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire la poche à vide selon IG 0012.

Laisser sécher pendant 4 heures minimum.

Heure début Curing: 3:30

Heure Fin Curing: 9:45

Date: 9-11-11

sceau:



16.0

AM90286

Catalyst N° DDM-9

Commentaire Qty.: 0.0120 GALLON(s)/Unit Total : 0.0120 GALLON(s)

Catalyst N° DDM-9

N° de Lot: 1-27829-1

17.0

AMB0212

Résine (411B7530) 411-350 promo. 75min.

Commentaire Qty.: 0.300 LITRE(s)/Unit Total : 0.300 LITRE(s)

Résine (411B7530) 411-350 promo. 75min

N° de Lot: 1-32912-1

18.0

PREP-GENERAL

Préparation du matériel



Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Faire la préparation de la résine selon les quantités requises, mix ratio 1.5% catalyst par quantité de résine et imbibier toutes les surfaces du Foam Core selon IG0105.

Date: 9-11-11

Sceau:



19.0

DKC134-0057

Foam Core N° D3186-102 (Porte D3186-2)

Commentaire Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)

Foam Core N° D3186-102 (Porte D3186-2)

N° de Job: 34925

20.0

AAC1611

Polybond B46F

Commentaire Qty.: 0.090 KIT(s)/Unit Total : 0.090 KIT(s)

Polybond B46F

N° de Lot: 1-27795-1

21.0

ASSEMBLAGE

Assemblage mécanique



Commentaire Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Retirez le haggging

Pour aider au positionnement de 12 oz., positionner le gabarit de trimage dans le moule et tracer son contour sur le 9 oz. Retirez le gabarit de trimage.

Positionner le foam core à l'aide du gabarit prévu à cet effet et tracer le contour sur le 9 oz. (Vous devriez maintenant avoir 2 contours de tracé sur le 9 oz.)

Date: Mardi, 2011-10-25 18:32:50
Utilisateur: Pascal Carignan

Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Numéro Job: 36774

Nom Dessin: SPACEPOD DOOR RH

Numéro Article: DKC134-0060

Numéro Job:



Séq.:

Machine ou Opération:

Description :

Appliquer une couche de Polybond B64F à l'endos du Foam Core N° DKC134-0057 et positionner le foam Core sur le moule selon le dessin, et selon les lignes de positionnement prévues à cet effet.

Date: 10/11/11 Sceau:



22.0

BAGGING

Faire le bagging sur la pièce



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire la poche à vide selon IG 0012.

Retirer le bagging avant la fin de la polymérisation (entre 1h et 1h30) afin d'enlever le surplus de Polybond.

Heure début Curing: 10:30

Heure Fin Curing: 11:50

Date: 10/11/11 sceau:



23.0

AMB0286

Catalyst N° DDM-9

Commentair Qty.: 0.0400 GALLON(s)/Unit Total : 0.0400 GALLON(s)
Catalyst N° DDM-9 N° de Lot: 1-27829-1

24.0

AMB0212

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 1.000 LITRE(s)/Unit Total : 1.000 LITRE(s)

Résine (411B7530) 411-350 promo. 75min N° de Lot: 1-32912-1

25.0

PREP-GENERAL

Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Faire la préparation de la résine selon les quantités requises, mix ratio 1.5% catalyst par quantité de résine.

Date: 11-11-11 Sceau:



26.0

LAMINAGE

Faire le laminage



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Faire le laminage d'un pli de 9.7 oz.

Faire le laminage d'un pli de 12 oz. tout le tour de la porte.

Faire le laminage d'un pli de 9.7 oz.

Date: 11/11/11 Sceau:



Date: Mardi, 2011-10-25 18:32:50
Utilisateur: Pascal Carignan

Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: SPACEPOD DOOR RH

Numéro Job: 36774

Numéro Article: DKC134-0060

Numéro Job:



Séq.:

Machine ou Opération:

Description :

27.0

BAGGING

Faire le bagging sur la pièce



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire la poche à vide selon IG 0012.

Laissez Sécher 4 heures minimum

Heure début Curing: 12:45

Heure Fin Curing: 8:00

Date: 11/11/11 sceau:



28.0

DÉMOULAGE

Démoulage de la pièce



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Démouler la pièce en faisant bien attention aux coins & Edges.

Sabler la surfaces de la pièce qui était en contact avec le moule afin d'éliminer le fini lisse de celui-ci.

Date: 16-11-11 Sceau:



29.0

TRIMAGE

Trimage



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Trimer le contour de la pièce à l'aide du gabarit de trimage prévu à cet effet.

Date: 16-11-11 Sceau:



30.0

AAC1021

Dupont Primer N° 7704S

Commentair Qty.: 0.1400 UNITE(s)/Unit Total : 0.1400 UNITE(s)

Dupont Primer N° 7704S

N° de Lot: 1-30270-1 Batisseur 12

31.0

AAC1101

N° 7775S, Dupont Activator - Reducer Chromabase

Commentair Qty.: 0.0283 UNITE(s)/Unit Total : 0.0283 UNITE(s)

N° 7775S, Dupont Activator - Reducer Chromabase

N° de Lot: 1-31394-2

32.0

PRIMER

Application primer



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Appliquer une couche de primer selon IS 0008.

Date: 17/11/11 Sceau:
















de fiche de mélange:

N/A

Batisseur 2e cdé
1er cdé

Date: Mardi, 2011-10-25 18:32:51
Utilisateur: Pascal Carignan

Feuille de Procédé

Client: DART US DART AEROSPACE LTD		Nom Dessin: SPACEPOD DOOR RH	
Numéro Job: 36774		Numéro Article: DKC134-0060	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
33.0	AAC1492	N° P-15-3, Adtech Micro Ultra Filler	
Commentaire Qty.: 0.010 GALLON(s)/Unit Total : 0.010 GALLON(s) N° P-15-3, Adtech Micro Ultra Filler		N° de Lot: 1-33224-1	
34.0	FINITION	Finition Générale	
			
Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Faire les réparations de finition si nécessaire à l'aide du "Filler" P15-3. Faire un léger sablage (Grit 220) de toutes les surfaces. Date: 17-11-11 sceau: 			
35.0	AAC1021	Dupont Primer N° 7704S	
Commentaire Qty.: 0.1400 UNITE(s)/Unit Total : 0.1400 UNITE(s) Dupont Primer N° 7704S		N° de Lot: 1-31638-3	
36.0	AAC1101	N° 7775S, Dupont Activator - Reducer Chromabase	
Commentaire Qty.: 0.0300 UNITE(s)/Unit Total : 0.0300 UNITE(s) N° 7775S, Dupont Activator - Reducer Chromabase		N° de Lot: 1-31394-2	
37.0	PRIMER	Application primer	
			
Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Appliquer une couche de primer selon IG 0008. Date: 18-11-11 Sceau:  # de Fiche de mélange: N/A			
38.0	INSPÉC FINAL	Inspection finale	
			
Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs Faire l'inspection finale par la qualité selon le dessin. Date: 21-11-11 Sceau: 			
39.0	EMBAL / ENTREPO	Emballage & Entreposage	
			
Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Emballer et entreposer selon IG 0057. Date: NOV 22 2010 Sceau: 			



Innovation en 3D

2699, 5E AVENUE, LOC. 14, C.P. 123, GRAND-MÈRE, QUÉ, G9T 5K7
TEL : 819-533-5788 FAX : 819-533-3494
email : delastek @ delastek.com

AQ-5

INSPECTION REPORT

INSPECTION REPORT NAME : INDKC134-0060.doc

PRODUCT IDENTIFICATION

DELASTEK

Cage Code : 3AR20

Spacepod door RH

TECHNICAL CONFIGURATION

CUSTOMER : DART

P/N DELASTEK : N/A

SUPPLIER CODE : VU-DEL0003

REFERENCE DELASTEK : DKC134-0060

P/N CUSTOMER: D3186

NEXT LEVEL : N/A

ACCEPTANCE TEST PROCEDURE : N/A

DRAWING # : D3186

REV : E

ACCEPTANCE TEST SHEET : N/A

PART LIST # : D3186

REV : E

PURCHASE ORDER MANAGEMENT

P.O. : N/A

P.O REV.: N/A

PACKING SLIP : N/A

UNINCOPR EOs : N/A

MEPI : N/A

PHYSICAL CHANGE : N/A

MFG DATE : N/A

WORK ORDER : 36774

SERIAL NUMBER :

OTHER DOCUMENTATION : N/A





☐ FIRST ARTICLE

☒ FINAL INSPECTION

PART LIST

Qty	DESCRIPTION	PART NUMBER	LOT NO.	COMMENTS
Vérifiée à partir de la feuille de procédé				

INSPECTION

OPERATION	ACC.	REJ.	% INSP.	METHOD OF INSPECTION	COMMENTS
Tap test dans les zones de foam	1	0	100	Visuel	
Primer	1	0	100	Visuel	
Pas d'identification	1	0	100	Visuel	 



Innovation en rôle

2699, 5E AVENUE, LOC. 14, C.P. 123, GRAND-MÈRE, QUÉ, G9T 5K7
TEL : 819-533-5788 FAX : 819-533-3494
email : delastek @ delastek.com

AQ-5

INSPECTION REPORT

INSPECTION REPORT NAME : INDKC134-0060.doc

FINAL ACCEPTANCE BY:



DATE :

QUANTITY : ACCEPTED :

1

REFUSED: 0

NCR# :

N/A

COMMENTS :